

Date: Wednesday, 3/8/2006 10:47:20 AM  
 Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BACKER PLATE
Job Number	: 26152		
Estimate Number	: 11803		
P.O. Number	: N/A	Part Number	: D25283
This Issue	: 3/8/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2528 REV C I
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: C I
	Type : MACHINED PARTS	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 3/30/2006
Checked & Approved By	: <u>06.03.08</u>	Qty:	50
Comment	: Est:C 00.06.26 Removed P/O for powder coat EC	Um:	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S063	5052-H32 .063 Sheet
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Comment: Qty.: 0.0319 sf(s)/Unit Total : 0.6384 sf(s)

5052-H32 .063 Sheet

Material: 5052-H32 Sheet (QQ-A-250/8) 0.063" thick

(M5052H32S.063)

Batch: M19296

SAD 06:03:23

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut blanks: 1625" x 2.460" +/- .010"

SAD 06:03:23

50

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill holes as per Dwg D2528 using Drill Jig DT 8248B

Deburr

SAD 06:03:23

50

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.F. 06-03-24

50

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

FL

51

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: 27 Date: 06/03/30  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 3/8/2006 10:47:20 AM  
User: Kim Johnston

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Drawing Name: BACKER PLATE

Job Number: 26152

Part Number: D25283

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*M DL 06/03/27 51*

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*M 06 03 27 51*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Y8*

*04/3/29 (51)*

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*D 06/03/30 (51)*

Job Completion



*U 06/03/29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2528	REV. C SHEET 1 OF 1
DATE 98.12.10		TITLE BACKER PLATE	SCALE 1:1
A	96.12.12	NEW ISSUE	
B	97.10.10	CHANGE SIZE AND HOLE LOCATION	
C	98.12.10	ADD D2528-1 AND -3 (TSR A1037) UPDATED TOLERANCES	
CI	<del>05.04.27</del>	1.46 WAS 1.460; 1.00 WAS 1.000	

RELEASED  
98.12.11 *KE*

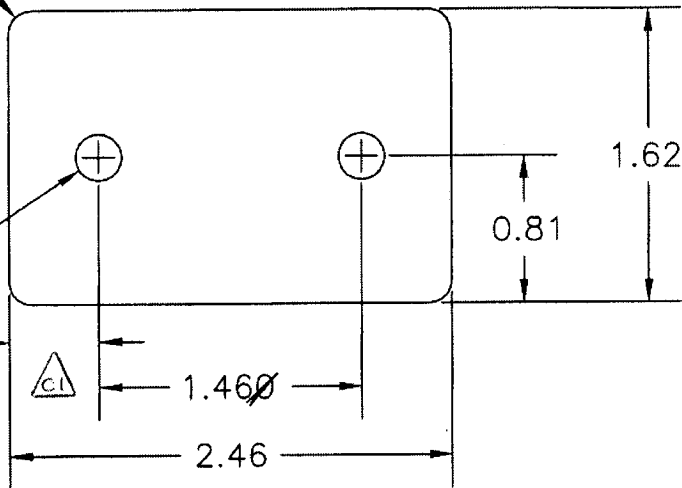
R0.13 (TYP)

UNDER REVIEW  
*[Signature]*

*OK 03.12.03*

Ø0.257 (TYP)

0.50

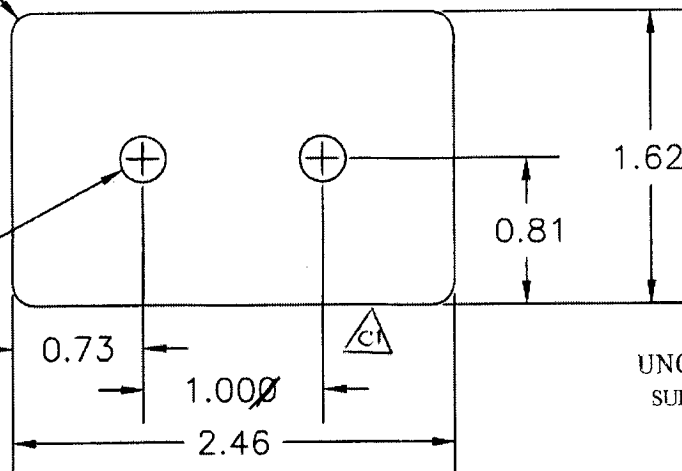


D2528-1

R0.13 (TYP)

Ø0.257 (TYP)

0.73



D2528-3

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26152

MATERIAL: 5052-H32 OR 5052-H34 (QQ-A-250/8) OR 2024-T3  
(QQ-A-250/4) OR 6061-T6 (QQ-A-250/11) 0.063 THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED